

CLAIMS

1. A method for manufacturing a hollow model having a hollow part having at least one opening communicating with an outside, characterized by comprising:

5 a core article forming process comprising a padding forming process for forming a padding made of a foamed material (B) and having a size acceptable to the hollow part and a film forming process for applying a film forming component (A) on the padding in order to form a
10 film having an external form similar to said hollow part;

a hollow model forming process that said core article formed in the core article forming process is set in a mold for forming an external form of the hollow model, two-component reaction rapid curing type urethane liquid resin (D) is injected into an interstice between them to be
15 cured, and then the hollow model having the core article inside thereof is formed by demolding;

a padding removing process that organic solvent (E) is injected into the film comprising the film forming component (A) to dissolve and remove the padding comprising the foaming material (B); and

20 a film removing process that the film from which the padding was removed is pulled up through the opening to remove.

2. A method for manufacturing a hollow model according to claim 1, characterized in that said film forming component (A) is preferably
25 flexible reaction curing urethane for injection with 50 to 90 in Shore hardness A, and said foaming material (B) is preferably expanded

polystyrene.

3. A method for manufacturing a hollow model according to claim 1 or 2, characterized in that said two-component reaction curing type urethane liquid resin for injection (D) consists of multi-functional polyol component (F), multi-functional polyisocyanate component (G) and a plasticizer (H), and said plasticizer (e) is micro-dispersed through phase separation within 5 minutes of a working life.
- 10 4. A method for manufacturing a hollow model according to any one of claims 1 to 3, characterized in that said two-component reaction curing type urethane liquid resin (D) has a minute particulate wax component (I) and a very small quantity of moisture (J) at a specific rate to be foamed urethane containing contributed wax minute particles.
- 15 5. A precious molding method by a lost wax method characterized by using said hollow model manufactured by a method for manufacturing a hollow model according to any one of the claims 1 to 4.
- 20 6. A precious molding manufactured by a precious molding method according to claim 5.